

Date: Wednesday, 27/08/2008 3:15:35 PM  
 User: Julie Lecocq

## Process Sheet

SPLIT - 1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP WELDMENT	
Job Number	: 41648 - 1			Part Number	: D3562041	
Estimate Number	: 12576			Drawing Number	: D3562 REV E	
P.O. Number				Project Number	: N/A	
This Issue	: 27/08/2008 S.O. No. :			Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: 27/08/2008 Type : LARGE FAB ASSY			Due Date	: 08/09/2008 Qty:	
Previous Run	: 41245				Um: Each	
Written By						
Checked & Approved By	: JLD 08-8-24					
Comment	Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD Est Rev:C ECN1048 07-12-18 DD verified by:ec Est Rev:D 08-07-28 add chemical conversion coat DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion 40937	
		Check Material for any Dents or Defects	SAD 08/08/28 (4)
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1  1-Cut D2622 extrusion as per Dwg D3562  2-Deburr and bevel ends for welding	SAD 08/08/28 (4)
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	SAD 08/08/28 (4)
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1	22/08/28/28 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2734 End Cap B35179

SP 08.11.10 (H)

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M104855

SP 08.11.10 (2)

2-Grind end cap welds flush as per Dwg D3562

SAO 08.11.10 (2)

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DA08/11/11 (2)

14.0 QC5 INSPECT WORK TO CURRENT STEP



08.11.12 (2)

(P10)

Comment: INSPECT WORK TO CURRENT STEP

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fx 08/11/12 (2)

16.0 POWDER COATING POWDER COATING



M109152

(2X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:00

OVEN TEMPERATURE: 320° F

FINISH TIME: 8:30

M-F 08/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-041 PAR #: Fault Category: NCR: Yes  No  DQA: *AS* Date: 08.11.18

Resolution: Disposition: QA: N/C Closed: Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.11.11	12-0	Foreign object found in the step.  R.C.: Excess magnabond fell off of the rivets.	<i>QSI 042</i>	Drill a hole as necessary on the to corner of the end cap to remove foreign object. * Do Not exceed hole size of 0.250". * fill hole with weld per QSI 004, i. ground finish.	<i>8.11.12</i>	<i>QSI 042</i>	<i>QSI 042</i>	<i>08.11.11</i>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: m109219

FZ 08/11/13 ②

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 08/11/13 ②

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

GA

SP 08/11/13 ②

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13 ②

Job Completion



MF 08-11-14

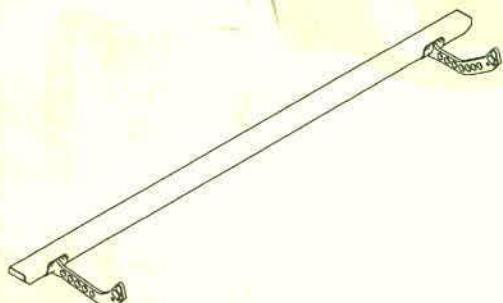
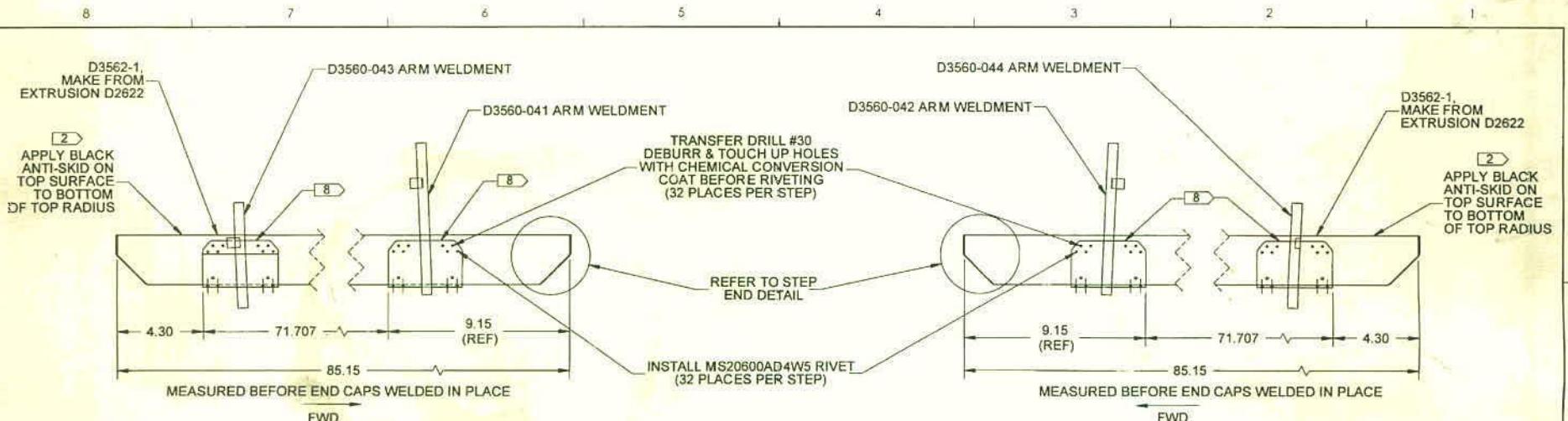
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

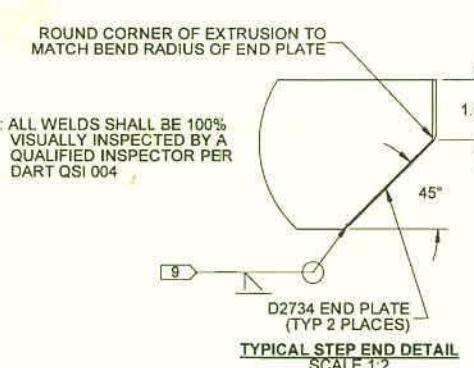
NOTE: Date & initial all entries



**D3562-041 LH STEP ASSEMBLY**

#### NOTES

- 1) MATERIAL: N/A
  - 2) FINISH:
    - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
    - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 8.79 lbs
  - 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
  - 9) WELDING: PER DART QSI 004



D3562-042 RH STEP ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042		PH	08.07.11
D	REMOVE D2808 SPACER NOTE: REDRAWN IN SOLIDWORKS		DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS		CP	07.06.19
B	ARMS NOW RIVETED TO STEP		CP	07.01.15
A	NEW ISSUE		CP	06.08.26
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>99</i>		DART AEROSPACE LTD	
DRAWN	<i>R4</i>		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LE</i>		DRAWING NO.	REV. E
MFG. APPR.	<i>N</i>		D3562	SHEET 1 OF 1
APPROVED	<i>MP</i>		TITLE	SCALE
DE APPR	<i>H</i>		STEP ASSEMBLY	1:5
DATE	08.01.11		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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MAGNOBOND 6398. CL  
9) WELDING PER DART C  
NO. 11164  
WORK ORDER  
WITHOUT NOTICE  
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RETURN TO  
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